

Work Order ID 146984

Tuesday, May 24, 2016 10:39:49 AM

146984

Page 1

Item ID: D3531-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Top Mounted Gps Bracket
 Start Date: 5/24/2016 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 5/31/2016 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MCS Date: MAY 26 2016 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3531	B

100	Small Fab	0.00							
100									
Small Fab	Memo	0.16							
Small Fab	Transfer drill holes, Dimples sink and assemble as per dwg D3531								

DAS
36
9-89

110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.02							
Quality Control									

DAS
38
9-89
JUL 19 2016

120	Black Sandtex(Ref:4.3.5.7) per OSI005 4.3	0.00							
120									
Powdercoat	Memo	0.13							
Powder Coating	START TIME: <u>1:40</u> OVEN TEMPERATURE: <u>350</u> FINISH TIME: <u>2:10</u>								

1 φ 1607-25838

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐				Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐				Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐				Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐											
		OTHER :																							

146984

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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 5/24/2016 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 5/31/2016 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop ***NR2***

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

**Insp.
Stamp**

0.00

130

QC

Memo

0.01

Quality Control

JUL 25 2016

Identify as per dwg & Stock Location: 01503

0.00

140

Packaging

Memo

0.01

Packaging

DAS
6
9-89

JUL 26 2016

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.10

Quality Control

**DAS
21
9-89**

JUL 27 2016

DAS
21
9-89

JUL 27 2016

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Misidentified ☐	Past Due ☐																																																																

Picklist Print

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Work Order ID: 146984

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Parent Item: D3531-041

D3531-041

Parent Item Name: Top Mounted Gps Bracket

Start Date: 5/24/2016

Required Date: 5/31/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 07-09-24 EC verified DD
12.10.24 PER DWG REV.B DD VERF:JLM

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3531-1 *D3531-1* Bracket		Manufactured	No			100	Each	2.0000	1	1		16/07/19	DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				2				146982 (1x)	
					142152			2					
D3531-3 *D3531-3* Bracket Front Plate		Manufactured	No			100	Each	1.0000	1	1		16/07/19	DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				1				146983 (1x)	
					119562			1					
MS20426AD4-4 *MS20426AD4-4* Rivet		Purchased	No			100	Each	4,475.000	2	2		16/07/19	DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				2022				2	
					125445			2022					
				ST312				2453					
					m132536			2453					

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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
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Parent Item: D3531-041

D3531-041

Parent Item Name: Top Mounted Gps Bracket

Start Date: 5/24/2016

Required Date: 5/31/2016

Start Qty: 1.00

Required Qty: 1.00

MS20470AD4-4

Purchased

No

100

Each

2,067.000

10

10

MS20470AD4-4

Rivet, Universal Head

DAS
36
9-88

16/07/19

Location

Loc Qty

Loc Code

GA

1599

M133922

54

M134294

101

M134574

1444

ST310

468

M132803

468

134848
(10X)

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